ί.	er ID 61950 ber 13, 2010 8:20:31 A	4 <i>M</i>											Page 1
Revision ID:	D412-711-101  Replacement Bubble Win	ıdow	•	Accept						Setu	p Star Stop		
Start Date: Required Date: Reference:		ty: 1.00 Qty: 1.00				Cust Item II Customer:	D:					1 10011101	
Approvals:	Process Plan:QC:	H	Date: 10-9-13	Tooling: SPC (Y/N):			te:			Run	Star Stop		
Sequence ID/ Work Center IL	Operation Descript			Set Up/ Run Hours		Tool ID	Tool#	Plan Code	Accep Qty		Reject Ety	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr												
D412-711-101  100  DC  Document Control	A		oluefiles and create labels 2-711-101 Change 002	0.00	113				}	<b>s</b> ) <u>c</u>	Cor.	BG	10-9-2
110 HandThermo	HAND FIN	NISHING THE	ERMOFORMING	0.00					H	1	10	100 f	) H

120

HandThermo

Hand Finishing Thermoforming

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Memo

0.00

0.00

Set up Machine as per folio FTA 077 and D711W program

Cut Blanks to 36" by 39"

W/O:		<del></del>	WO	RK ORDER CHANG	GES				
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cateo	jory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
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		Description of NC		Corrective Action Sec	ction B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector
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#### Work Order ID 61950

Monday, September 13, 2010 8:20:31 AM



Page 2

' Item ID:

D412-711-101

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

**Required Date: 9/20/2010** 

Replacement Bubble Window

**Start Date:** 

9/13/2010

Start Oty: 1.00

Reg'd Otv: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Date:

Tooling:

Set Up/

**Run Hours** 

Date:

Date:

Start Run



SPC (Y/N):

Tool ID

Tool # Plan

Code

Accept Qty

Reject Otv

Stop

Reject Insp. Number Stamp

Work Center ID 130

Sequence ID/

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

0.00

0.00

Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077

Dwg. Rev.

Folio Rev.

140

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1) Check Surface finish for undesired marks, voids, dimples etc. 2) Check depth of bubble to ensure conformity to drawing tolerances.

J. 10/09/20

150

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

									7
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
<i>57112</i>	J. L.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	on C	Chief Eng	QC Inspector
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#### Work Order ID 61950

Quality Control

Monday, September 13, 2010 8:20:31 AM

Memo

1) VIsually inspect for clarity, and proper formation.



Page 3

D412-711-101 Item ID: Accept Setup Start **Revision ID:** Stop Replacement Bubble Window Item Name: Start Oty: 1.00 Start Date: 9/13/2010 **Cust Item ID: Required Date: 9/20/2010** Req'd Otv: 1.00 **Customer:** Reference: Start Run Process Plan: Date: Approvals: Tooling: Date: \_\_\_\_\_ Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Accept Reject Reject Insp. Work Center ID Description Qty **Run Hours** Code Qty Number Stamp 160 0.00 FB /10/09/20. HAND FINISHING THERMOFORMING HandThermo 0.00 Memo Hand Finishing Thermoforming 1) Trim off excess flange material 2) Buff out any light scratches or blemishes 3) Etch part number and batch number 170 QC2- Inspect parts off machine FAI/FAIB 0.00 BB 10/09/21 QC 0.00 Memo Quality Control 1) VIsually inspect for clarity, and proper formation. 180 QC5- Inspect part completeness to step on W/O 0.00

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W/O:			WC	ORK ORDER CHANG	ES		_ · · · · · · · · · · · · · · · · · · ·		
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	Date:	
	Res	olution:	Dispositio	n:	_ QA: N/C Cld	osed:		Date: _	·
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC	·	Corrective Action Section			cation	Approval	Approval
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	tion C	Chief Eng	QC Inspector
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#### Work Order ID 61950

Monday, September 13, 2010 8:20:31 AM



Page 4

Item ID:

D412-711-101

Accept

Setup Start

Revision ID:

Item Name:

**Required Date: 9/20/2010** 

Replacement Bubble Window

Start Date:

9/13/2010

QC:

Start Otv: 1.00

Rea'd Otv: 1.00



Date:

**Cust Item ID:** 

Customer:

Reference:

Approvals:

Process Plan:

Date: Tooling:

Date: Date:

Start Stop

Stop



Sequence ID/

Work Center ID

Quality Control

Operation Description

QC4- 100% Inspect kits for completeness

Memo

Set Up/ Run Hours

SPC (Y/N):

0.00

0.00 S 10/09/23

Tool ID

Tool # Plan Code

Accept Oty

Reject Oty

Run

Reject Insp. Number

Stamp

190

Packaging

Packaging

Identify as per dwg & Stock Location

Memo

0.00

200

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/27 XX) MF-9-04

W/O:			W	ORK ORDER CHANGI	ES			
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No DQA:	Date: _	
	R	esolution:	Disposition	on:	_ QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORE	ER NON-CONFORMA	NCE (NCR)	)		
DATE	STEP	Description of NC		Corrective Action Section		Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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### **Picklist Print**

Monday, September 13, 2010 8:20:35 AM

Work Order ID: 61950

Parent Item: I

D412-711-101

Parent Item Name:

Replacement Bubble Window



**Start Date:** 9/13/2010

Required Date: 9/20/2010

Page 1

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev:A New Issue 06-02-01

JLM

Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236	10	Purchased	No				sf	113.0000	16	16			

Plexiglass G .236"

Location	Loc Qty	Loc Code			
therm	113				
113571	17				
115096	16			10	1 6
115590	80		20-syft.	Wa	10/08/20
•			0		' /

W/O:			WC	RK ORDER CHAN	GES					r ,
DATE	STEP	PRO	OCEDURE CHA		В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Cate	gory:	NCR: `	Yes N	lo <b>DQ</b>	<b>A</b> :	_ Date: _	
	Re	esolution:	Disposition	n:	QA: N/	C Clos	sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	JANCE (I	NCR)				
DATE	STEP	Description of NC			ection B		Verifi	cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date		ion C	Chief Eng	QC Inspector
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	1
rt Number:	411-711-181
	Page 1 of 1
1	rt Number:

# FIRST ARTICLE INSPECTION CHECKLIST THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than"	î-			
Shape Definition	-			
Texture Retention	i/			
Material imperfections such as bumps, cracks, voids, scratching				

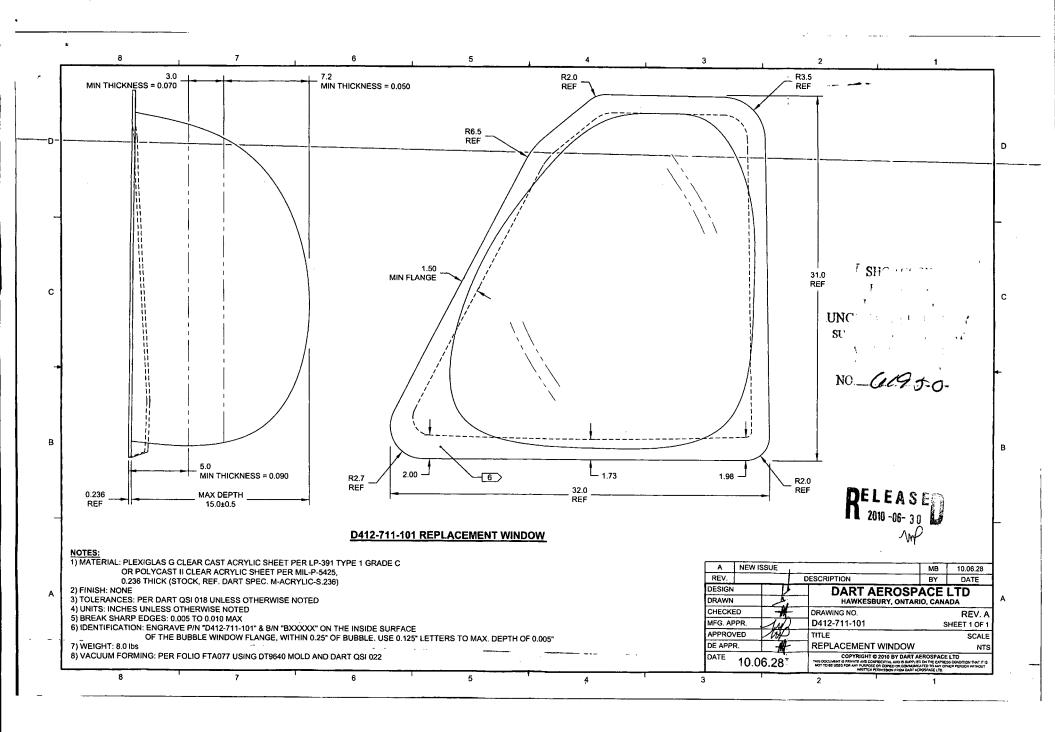
		7			<del>/</del>
Measured by:	14	'	Date: //	1091	30
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#### TRIMMING SECTION

					<del>,</del>	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.0 "	4- 6.036	2.07				
1.73"	× 0.030	1,75				
198"	4-0.030	1.49"	•			
1.504	tr- 0.030	1.541	00000			
0.090"	MA A MAO	1.09"	<u></u>			
0.070"	min	0.0471	<u> </u>			
0.050"	MIN.	0,078				
						<u> </u>

Measured by:	Date: 10-/04/21
Audited by:	Date: 10/09/20
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
В	10.04.14	Added preliminary approval	KJ	<u> </u>



W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE			В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
								·		`	
									•		
Part No:		PAR #:	Fault Category: N			ICR: Yes No DQA: Date:					
Resolution:			Dispositio	Disposition: Q			A: N/C Closed: Date:				
NCR:			WORK ORD	ER NON-CONFORMA	ANCE (I	VCR)					
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